

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009385**Date Inspected:** 29-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li zhi jiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

OBG # BAY 01

This QA inspector performed Magnetic Particle Test of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Magnetic Particle Test report for this date. The member is identified as Counter Weight. The weld designations reviewed are as follows:

(CW001-PP068-131,132)

(CW001A-PP068-001) Green Tag # 10000

(CW002B-PP098-007,016,020)

(CW002A-PP098-002,004,008)

OBG # BAY 02

This QA inspector performed Magnetic Particle Test of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Magnetic Particle Test report for this date. The member is identified as Floor Beam. The weld designations reviewed are as follows:

(FB3062-001-002,003,004,005,006,016,017,018,021,040,044)

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

OBG # BAY 03

This QA inspector performed Magnetic Particle Test of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Magnetic Particle Test report for this date. The member is identified as Floor Beam. The weld designations reviewed are as follows:

(FB023-010-125,126,127)

This QA Inspector randomly observed the following work in progress:

OBG # BAY 02

Flux Cored Arc Welding Process:

Welding of weld joint –022,023 located on PCMK FB3055-001. Welder is identified as 206358. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –022,023 located on PCMK FB3053-001. Welder is identified as 045203. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –021,022 located on PCMK FB6501-001. Welder is identified as 045209. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

OBG # BAY 03

Flux Cored Arc Welding Process:

Welding of weld joint –022,023 located on PCMK CSD9-PP99. Welder is identified as 208035. ZPMC QC is identified as Yin dong hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –100,101 located on PCMK CSD9-PP98. Welder is identified as 208035. ZPMC QC is identified as Yin dong hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –021,022 located on PCMK CSD9-PP98. Welder is identified as 044790. ZPMC QC is identified as Yin dong hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U4b-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

No Relevant Conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By:	Sukanthan,Dhanasingh
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Quality Assurance Inspector

Reviewed By:	Hall,Steven
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QA Reviewer
